

Date: Tuesday, 3/11/2008 10:28:36 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP HI LONG
Job Number : 37779	
Estimate Number : 12897	
P.O. Number :	Part Number : D32721
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D3272 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 11	Drawing Revision : B
Previous Run : 37778	Material :
Written By : <u>JA 08 03 11</u>	Due Date : 4/10/2008
Checked & Approved By : <u>JA 08 03 11</u>	Qty: <u>20</u> Um: Each
Comment : Est Rev: A New Issue 07-06-09 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2622120C	Extrusion
-----	-----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2622-120

Extrusion

B2693 B36923

SAO

08/03/23

20

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A SAO

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

SAO 08/03/25 20

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

08/03/25 (+20)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: UA

08/03/26 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 08/03/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 10:28:37 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP HI LONG

Job Number: 37779

Part Number: D32721

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



28

Comment: FINAL INSPECTION/W/O RELEASE

Done 103/26

Job Completion



U 08'03.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04 *ff*

B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

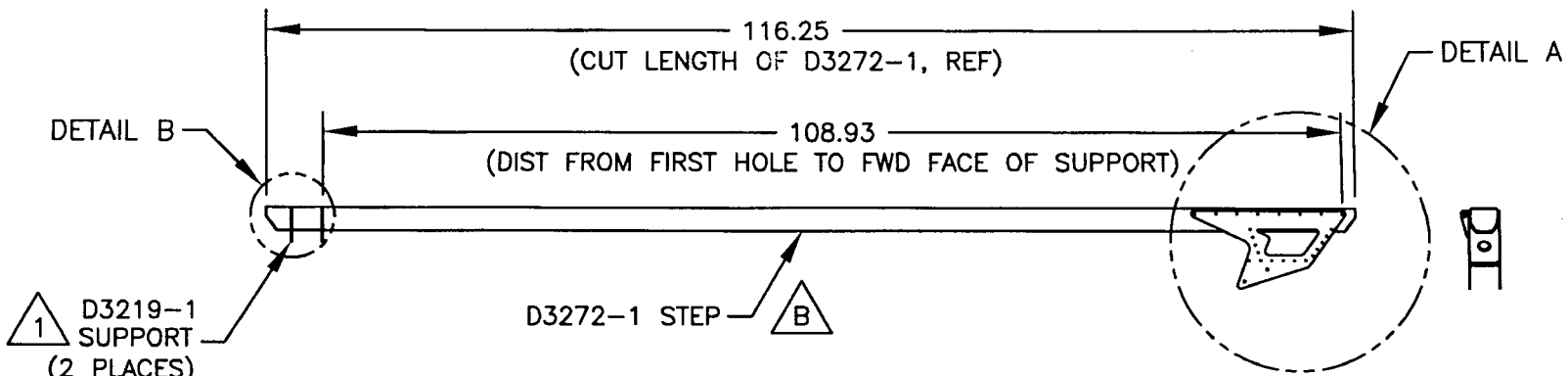
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WORK ORDER  
NO. 37779

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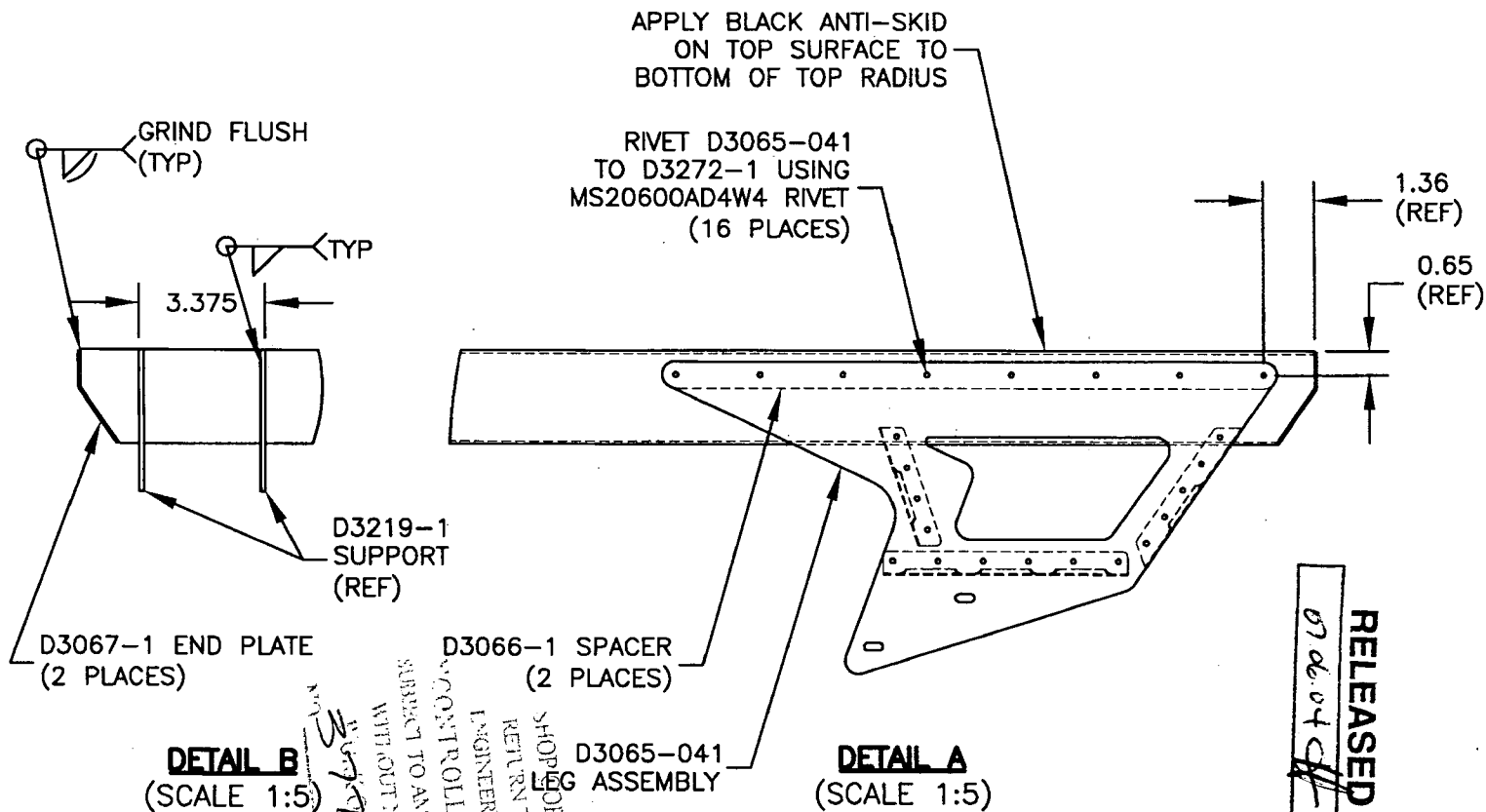
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3272	REV. B
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SHEET 2 OF 3	SCALE 1:20



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



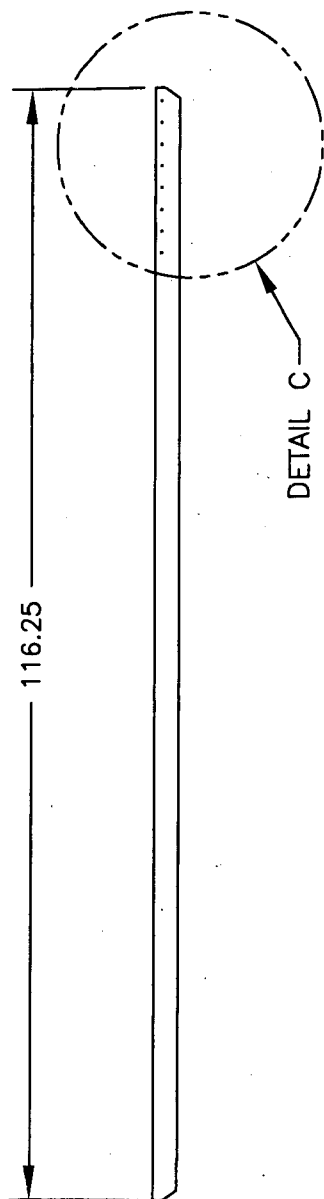
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07/09/19



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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

RELEASED

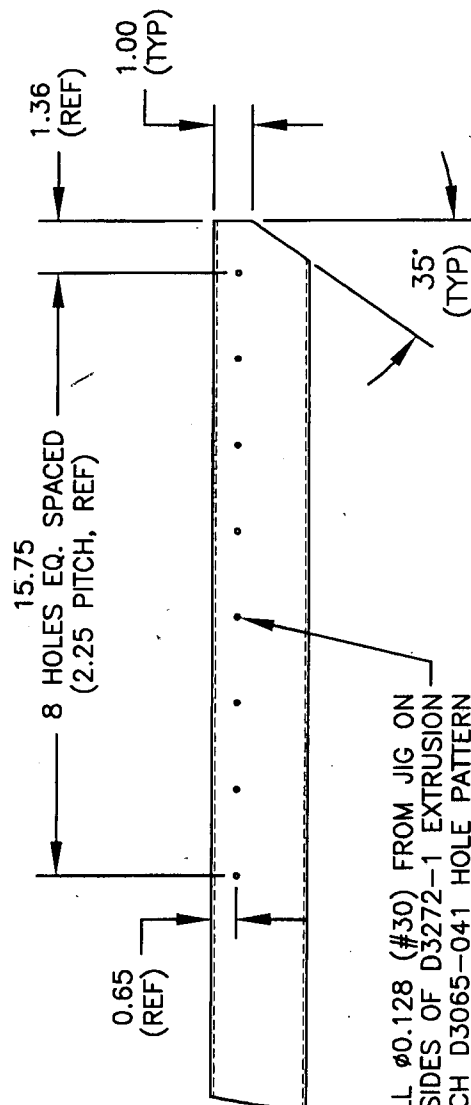
07.06.04 *[Signature]*



DETAIL C

**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)



**DETAIL C**  
(SCALE 1:5)

DRILL  $\phi 0.128$  (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

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